

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029860**Date Inspected:** 29-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist, Crest Hill, IL.**Location:** USA Hoist, 1000 Sak Drive**CWI Name:** None present**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Elevator guide masts**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) travelled this day to USA Hoist, 1000 Sak Drive, Crest Hill, IL. for the purpose of performing in-process inspections of Tower Elevator related fabricated members to the requirements of the contract documents.

Upon arrival to USA Hoist, this QAI proceeded to fabrication area of their facility to observe the operations to be performed that day.

This QAI observed the continuation of rework, welding, performed per USA Hoist Engineer, Robert Overbeek, directive to increase the weld sizes of the Tower Elevator guide masts. These weld areas are those of joints of members #1 and #10 where their curved sections form a flare-bevel groove type intersection with their adjacent members. This QAI had previously reported that the welds were undersized with regard to the weld symbols as provided on the drawings which are not approved as of this date. Mr. Overbeek and Tim Moran were also previously informed by this QAI of the discrepancy at the time of it's discovery, so it could be addressed towards a resolution.

The welder performing the rework repair welding was Matt Wasiqi, ID# "A", utilizing .045" diameter FCAW-G wire as per AWS D1.1 and the Welding Procedure Specification (WPS) identified as FCAW3139. There was no Quality Control (QC) Inspector present on this day. This QAI performed monitoring of in-process welding, verifying adherence to the WPS parameters. This work is in progress so far, with no members being fully completed this day.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

When asked by this QAI whether he had been contacted by General Machine & Tool Co. regarding the bending condition of member #18 of drawing #914204. Mr. Robert Overbeek replied that he had, and that the sample made were going to be sent over from there for his scrutiny and evaluation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Morris, Monty	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer

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